

5/05

DART AEROSPACE LTD	Work Order:	22234
Description: Arm	Part Number:	D2802-1
Dwg: D2802 rev A <i>B</i> <i>D3387 Rev A</i> <i>(P05.01.25)</i>	Qty:	1 <i>74</i>

05-01-18

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	<i>HA</i>	05.01.17	2
2	METAL	Cut blanks 15.800 <i>17.800</i> " long Material: 6061-T6 bar 6.00" x 0.50" Batch: <i>M9601</i> <i>M11409</i> <i>M11708</i>	<i>HA</i>	05.01.18	<i>4</i>
3	HAAS	Machine as per folio FA101	<i>SD</i>	05.01.18	<i>4</i>
4	CNC-CELL	Counter sink .375 dia as per dwg	<i>HA</i>	05.01.18	<i>4</i>
5	QC	Inspect Level 2	<i>SD</i>	05.01.18	<i>4</i>
6	QC	Inspect Level 8	<i>HA</i>	05.01.20	<i>4</i>
7	METAL	Tumble & Deburr NO sharp edges.	<i>HA</i>	05.01.20	<i>4</i>
8	QC	Inspect Level 5	<i>HA</i>	05.01.20	<i>4</i>
9	FINISHING	Chemical conversion coat as per QSI 005 4.3	<i>PD</i>	05.01.20	<i>4</i>
10	STORES	Identify and stock	<i>PD</i>	05.01.20	<i>4</i>
11	EXPEDITING	Close W/O Inspect level 21 Cost / part: <i>55.11</i> <i>Sub 08/01/21</i> <i>(4)</i> <i>97.81</i>	<i>HA</i>	05.01.21	<i>4</i>

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	
B	02.03.18	Re-format	NG	<i>P02-03-18</i>

RELEASED

02/03/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.01.18	2	Permanent Change	<i>[Signature]</i>	05.01.18	N/A	<i>[Signature]</i> 05.01.18	<i>[Signature]</i> 05.01.26

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.01.19	3	1 piece scrap 1 time run the program wrong dwg (wall wrong)	<i>[Signature]</i> 05.01.19	destroy & replace	<i>[Signature]</i> 05.01.19	<i>[Signature]</i> 05.01.19	<i>[Signature]</i> 05.01.19	<i>[Signature]</i> 05.01.19

Part No: 3387-1 ~~D2802~~ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 05/01/2019

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

PART AEROSPACE LTD		Work Order: 222 34
Description: Arm		Part Number: 02802-1
Inspection Dwg: D2802 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	± 0.01	0.506	✓			
1.700	"	1.703	✓			
0.188	"	.189	✓			
Ø.507	$\begin{matrix} +0.000 \\ -0.001 \end{matrix}$	Ø.506	✓			
2.033	± 0.005	2.028	✓			
Ø.191	$\begin{matrix} +0.005 \\ -0.000 \end{matrix}$	Ø.192	✓			
2.000	± 0.01	2.003	✓			
1.347	"	1.347	✓			
Ø.507	$\begin{matrix} +0.000 \\ -0.001 \end{matrix}$	Ø.507	✓			
Ø.250	± 0.01	.250	✓			
R.125	"	R.125	✓			
16.245	"	16.248	✓			
7.577	"					
0.250	"	.250	✓			
0.500 ±0.01 0.500 ✓						
0.500	"	.500	✓			
.135	$\begin{matrix} +.020 \\ -.000 \end{matrix}$.149	✓			
.280		.282	✓			
SCRAP						PROBLEM w/ Eng dwg needs thicker walls. SCRAP 1st part. Make with thicker walls per marked-up dwg 05.01.18

Measured by: SD	Audited by: E	Prototype Approval:
Date: 05/01.18	Date: 05.01.18	Date:

Rev A	Date	Change New Issue	Revised by KJ/JLM	Approved
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BART AEROSPACE LTD		Work Order: 22234
Description: ARM		Part Number: D2801 D3387+1
Inspection Dwg: D2801 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.125	± 0.016	R0.125	✓		Vern	
0.135	± 0.020 ± 0.000	0.150	✓		Hand Micro	
Ø0.375X100	± 0.010	Ø0.375X100	✓		Vern	
R0.032	± 0.010	R0.032	✓		R-G	
0.500	± 0.016	0.500	✓		Vern	
0.500	± 0.016	0.503	✓		Vern	
7.577	± 0.016	7.580	✓		H-G	
R0.125	± 0.016	R0.125	✓		Vern	
Ø0.507	± 0.000 ± 0.001	Ø0.5065	✓		Micro/T-G	
0.250	± 0.016	0.247	✓		Vern	
1.347	± 0.016	1.347	✓		Vern	
2.000	± 0.010	2.006	✓		Vern	
1.000	± 0.010	1.000	✓		Vern	
Ø0.191	± 0.005 ± 0.000	Ø0.194	✓		Vern	
R0.300	± 0.010	R0.300	✓		Vern	
2.033	± 0.010	2.033	✓		Vern	
0.280	± 0.016	0.283	✓		Vern	
0.222	± 0.010	0.223	✓		Vern	
1.700	± 0.016	1.704	✓		Vern	

Measured by: <i>JML</i>	Audited by: <i>EP</i>	Prototype Approval: <i>CP</i>
Date: 05/01/19	Date: 05/01/19	Date: 05/01/19

Rev A	Date	Change	Revised by	Approved
		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 22234
Description: ARM		Part Number: D3387-1
Inspection Dwg: D3387 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.125	± 0.06	R0.125	✓		R-G	
0.125	± 0.10	0.128	✓		Ver Mic	
$\emptyset 0.375 \times 100^\circ$	± 0.10	$\emptyset 0.380 \times 100^\circ$	✓		Vern	
R0.032	± 0.10	R0.032	✓		R-G	
0.500	± 0.10	0.506	✓		Vern	
1.347	± 0.10	1.347	✓		Vern	
2.000	± 0.10	2.005	✓		Vern	
1.000	± 0.10	1.000	✓		Vern	
$\emptyset 0.191$	± 0.005 ± 0.000	$\emptyset 0.194$	✓		Vern	
R0.300	± 0.10	R0.300	✓		R-G	
2.033	± 0.10	2.032	✓		Vern	
$\emptyset 0.507$	± 0.000 ± 0.001	$\emptyset 0.507$	✓		Mic/R-G	
0.250	± 0.10	0.253	✓		Vern	
0.188	± 0.10	0.189	✓		Vern	
1.700	± 0.10	1.705	✓		Vern	
R0.030	± 0.10	R0.030	✓		R-G	
0.500	± 0.10	0.506	✓		Vern	
0.300	± 0.10	0.301	✓		Vern	

Measured by: <i>gmk</i>	Audited by: <i>Ep</i>	Prototype Approval: <i>dp</i>
Date: 05/01/19	Date: 05/01/19	Date: 05.01.20
Rev A	Date	Change
		New Issue
	Revised by	Approved
	KJ/JLM	

DART



Replace
D2801-1/-2
Rev A
for this
batch

0.0015

Ø0.191
R0.300 (TYP)

- GENERAL NOTES**
- 1) MACHINE PER DRAWING FILE "D3387-A.DWG"
 - 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK
(REF DART SPEC. M6061T6B0.500)
 - 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. A
				D3387	SHEET 1 OF 1
DATE				TITLE	SCALE
05.01.18				ARM	1:3
A	05.01.18			NEW ISSUE	

1921/1922

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 17, 2005
10:23 am

Work Order No : 0022234
Project Name : D2802-1
Project For : WK505
Work Order Type : Sub
Main WO Number :
House Part Number : D2802-1
Description : Arm
Manufactured : Yes
Amount Req'd : 2
Amount Done : 0
Start Date : 01-17-05
Est Finish Date : 01-24-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00